



Dart Aerospace Ltd.
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D4148-041

Job Sheet 180593



Part No: D4148-041

Job Qty: 8 ea

Part Name: Fwd Crosstube Lug Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/10/18

Job Tracking No:

Due Date: 7/20/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV E SHEETS 1,2 IPP Rev:A 10.06.24 new issue DD verf:EC IPP Rev:B 10.07.22 as per revB DD
verf:JLM IPP Rev:C 10.10.29 as per revC DD verf:EC IPP REV:D 11.03.02 AS PER DWG REV.D DD
VERF:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	6 Ea	7/20/18	7/20/18	0.00	0.00	Start Up Small Fab-3		
100	Small Fab	6 pcs	7/20/18	7/20/18	0.00	1.80	Small Fab-6		
110	QC	6 pcs	7/20/18	7/20/18	0.00	0.00	QC5		
120	Packaging	6 pcs	7/20/18	7/20/18	0.00	0.00	Packaging3-2		
130	QC21-SA	6 Ea	7/20/18	7/20/18	0.00	0.00	QC21		

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3C12A	Bolt	12 Ea (2 ea)	90-Start up Operation	5084117
AN4C13A	Bolt	18 Ea (3 ea)	90-Start up Operation	5099292
D2690-6	Lanyard	6 Ea (1 ea)	90-Start up Operation	5091393 x 4
D3910-1	Crosstube Lug	6 Ea (1 ea)	90-Start up Operation	5071259 x 3
D4091-1	Mounting Lug	6 Ea (1 ea)	90-Start up Operation	5062930
D4148-1	Crosstube Lug Plate, Fwd	12 Ea (2 ea)	90-Start up Operation	5066756 x 5
D4148-3	Stud Receiver, Lower	6 Ea (1 ea)	90-Start up Operation	5088596
D4148-5	Eyebolt Stud	6 Ea (1 ea)	90-Start up Operation	5088428
MS17984-C413	Quick Release Pin	6 pcs (1 ea)	90-Start up Operation	5057527
MS20615-4M18	Rivet	48 Ea (8 ea)	90-Start up Operation	5083540 x 24
MS21043-3	Nut	12 Ea (2 ea)	90-Start up Operation	5062620
MS21043-4	Nut	18 Ea (3 ea)	90-Start up Operation	5062096
NAS1149C0332R	Washer	24 Ea (4 ea)	90-Start up Operation	5049837
NAS1149C0432R	Washer	36 Ea (6 ea)	90-Start up Operation	5050052

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3C12A	12	178	0
	AN4C13A	18	63	0
	D2690-6	6	15	0
	D3910-1	6	9	0
	D4091-1	6	36	0
	D4148-1	12	42	0
	D4148-3	6	12	0
	D4148-5	6	8	0

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

MS17984-C413
MS20615-4M18
MS21043-3
MS21043-4
NAS1149C032R
NAS1149C0432R

6
48
12
18
24
36

21
62
1,055
719
6,635
1,607

0
0
0
0
0
0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					